



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

URGENT

D2893-1
Job Sheet 170106



Part No: D2893-1

Job Qty: 20 ea

Part Name: Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/10/18

Job Tracking No:

Due Date: 1/15/18

Created By: Linda Lacelle

Type: SOLD

Description:

Customer: Falcon Aviation Services (CFALC01)

PO Box 62030 Abu Dhabi, , United Arab Emirates ph:011 971 50 445 0187 fx:+971 2 444 0022.

Note: DWG REV C IPP: C 02.11.26 Reformat; Added P/O KJ IPP D 06.04.19 removed alodine EC IPP Rev:E Added priming as per Rev B 07-04-30 JLM IPP F 08.03.19 Re-format EC verified by: DD IPP Rev:G 08-05-15 add QC14 DD verified by:EC IPP Rev:H 11.08.04 as per dwg rev.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		1/11/18	0.00	0.00	Start Up Machining-1		<i>FK 18-1-15</i>
100	CNC Vertical Machining	20 pcs		1/13/18	0.33	39.22	HAAS1-2		<i>SBL 18/01/16 / FK 18-1-18</i>
120	QC	20 pcs		1/13/18	0.00	0.00	QC8 Machining-1		<i>AK</i>
130	Crosstubes	20 pcs		1/15/18	0.00	3.33	Crosstubes-2		<i>AK JAN 19 7:19</i>
140	QC	20 pcs		1/15/18	0.00	0.00	QC3		<i>AK</i>
170	Packaging	20 pcs		1/15/18	0.00	0.00	Packaging3-1		<i>AK JAN 23 2018</i>
180	QC21-SA	20 Ea		1/15/18	0.00	0.00	QC21		<i>AK</i>

Part Op 100 - 1-Machine as per Folio FA081

Descriptions: 130 - Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg.

170 - LOCATION : LG050

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	DSK078	10	9	0	0

F162895 x 5
F160604-0 x 4

DART
AEROSPACE
S032424

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Support

PART NO: D2893 – 1

Original Serial #: S032424

Revision:

Operation: Start up Operation 01/15/18

Change No:

Job No: 170106

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	2.985Inches + 0.020 - 0.000	3.005 2.985		
2	2.750 Support	0.440Inches + 0.020 - 0.000	0.460 0.440		
3	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
4	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
5	2.750 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
6	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
7	2.750 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
8	2.750 Support	1.360Inches + 0.040 - 0.000	1.400 1.360		
9	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
10	2.750 Support	1.190Inches + 0.040 - 0.000	1.230 1.190		
11	2.750 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
12	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
13	2.750 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
14	2.750 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
15	2.750 Support	84.390Inches + 6.000 - 0.000	90.390 84.390		
16	2.750 Support	0.261Inches + 0.005 - 0.000	0.266 0.261		
17	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		

Plex 1/10/18 9:59 AM dart.lacelle.linda

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : <u>18/1/18</u>	Step #: <u>100</u>	QTY Effective : <u>2</u>		MRB (QSI042) Approval DAS <u>12</u> 9-89 <u>18/1/18</u>	
Description Work Order Deviation		Disposition		Completed By <u>18-1-19</u> <u>18/1/18</u>	
Dim 0.150 is 0.133 at one location. On second part, same dim is 0.138 P.C. operator grinded to much material.		Scrap. will affect interface with aircraft. <u>Part with 0.138 thickness is acceptable.</u>		Lead hand / Supervisor Approval Verification <u>18-01-18</u>	
QC / QA Coordinator Approval <u>18-01-18</u>					

Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☒	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	☒ Over/Under tolerance
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

DART AEROSPACE LTD		Work Order: 170 106
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2,990	2,990	3,000	2,999	3,000
AB	0.440	0.460		0,455	0,455	0,452	0,450	0,453
AC	0.125	0.160		0,155	0,150	0,155	0,155	0,154
AD	0.040	0.060		0,052	0,051	0,052	0,051	0,051
AE	0.188	0.193		0,190	0,190	0,190	0,190	0,190
AF	0.125	0.160		0,138	0,138	0,138	0,137	0,139
AG	0.140	0.160		0,145	0,148	0,147	0,143	0,154
AH	1.360	1.400		1,390	1,376	1,375	1,378	1,376
AI	0.040	0.060		0,053	0,049	0,045	0,049	0,050
AJ	1.190	1.230		1,230	1,218	1,212	1,219	1,217
AK	0.010	0.020		0,010	0,010	0,010	0,010	0,010
AL	0.053	0.073		0,063	0,063	0,063	0,063	0,063
AM	0.240	0.260		0,250	0,250	0,250	0,250	0,250
AN	2.518	2.538		2,525	2,528	2,530	2,528	2,530
AO	84.39	90.39		87,39	87,39	87,39	87,39	87,39
AP	0.261	0.266		0,261	0,261	0,261	0,261	0,261
AQ	0.053	0.073		0,063	0,063	0,063	0,063	0,063
AR								
AS								
AT								
Accept/Reject								

Measured by: SBL/18/01/16 / m	Date: 18/01/16
Audited by:	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 170 106
Description: Ø2.750 Support		Part Number: D2893-1
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FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		3.000	3.000	2.999	2.999	2.999
AB	0.440	0.460		.455	.453	.455	.450	.453
AC	0.125	0.160		.156	.156	.156	.154	.155
AD	0.040	0.060		.051	.052	.050	.050	.050
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.135	.137	.138	.140	.138
AG	0.140	0.160		.150	.149	.149	.147	.144
AH	1.360	1.400		1.373	1.377	1.375	1.378	1.375
AI	0.040	0.060		.050	.048	.048	.048	.049
AJ	1.190	1.230		1.213	1.216	1.212	1.216	1.210
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.531	2.532	2.533	2.530	2.531
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.263	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.061	.061
AR								
AS								
AT								
Accept/Reject								

Measured by: SBL	Date: 18/01/17
Audited by:	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 170 100
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11 ↑	12 ↑	13 ↑	14 ↑	15 ↑
HAAS Section								
AA	2.985	3.005		2.995	2.996	2.993	2.993	2.993
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.140	.140	.136	.138	.137
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.140	.142	.140	.141	.141
AG	0.140	0.160		.149		.149	.149	.149
AH	1.360	1.400		1.373		1.380	1.383	1.378
AI	0.040	0.060		.048		.049	.049	.049
AJ	1.190	1.230		1.212		1.219	1.223	1.220
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528		2.534	2.536	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject				✓	Scrap.	✓	✓	✓

Measured by: SBL / FK 18-1-18	Date: 18/01/17
Audited by:	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
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DART AEROSPACE LTD		Work Order: 170 106
Description: Ø2.750 Support		Part Number: D2893-1
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FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16 ¹	17 ²	18 ³	19 ⁴	20 ⁵
HAAS Section								
AA	2.985	3.005		2.993	2.993	2.993		
AB	0.440	0.460		.450	.450	.450		
AC	0.125	0.160		.139	.136	.139		
AD	0.040	0.060		.050	.050	.050		
AE	0.188	0.193		.188	.188	.188		
AF	0.125	0.160		.140	.140	.140		
AG	0.140	0.160		.147	.147	.147		
AH	1.360	1.400		1.378	1.376	1.379		
AI	0.040	0.060		.050	.048	.048		
AJ	1.190	1.230		1.221	1.213	1.220		
AK	0.010	0.020		.015	.015	.015		
AL	0.053	0.073		.063	.063	.063		
AM	0.240	0.260		.250	.250	.250		
AN	2.518	2.538		2.531	2.532	2.530		
AO	84.39	90.39		87.39	87.39	87.39		
AP	0.261	0.266		.261	.261	.261		
AQ	0.053	0.073		.063	.063	.063		
AR								
AS								
AT								
Accept/Reject				✓	✓	✓		

Measured by: FK **Date:** 18-1-18

Audited by: **Date:**

Preliminary Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
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